

Work Order ID 72650

Page 1

Wednesday, August 03, 2011 2:45:51 PM

Item ID: D3914-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Long Basket Lid Assembly (350)

Start Date: 8/3/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/12/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3914

B

100

Weld per dwg A/R S.S. rod Batch: M114649 0.00

Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble ribs , weld as per dwg D3914 using DT9607A
2- weld hinge (3) and Mounting brackets as per dwg D3914
inspect before welding mesh
3- tack weld mesh on basket as per dwg D3914
***make sure to place mesh correctly on lid, check with label plate before
tacking mesh***

PMB 11/08/03
GL 11-08-11

110

QC9- Inspect visual per QSI004- Fusion Welds 0.00



QC

Memo

0.00

Quality Control

11-08-12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries

Work Order ID 72650


Wednesday, August 03, 2011 2:45:52 PM


Page 2

Item ID:	D3914-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Long Basket Lid Assembly (350)					
Start Date:	8/3/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	8/12/2011	Req'd Qty:	1.00		Customer:	
Reference:						


Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120	QC6- Inspect dimensions to drawing	0.00							
									
QC	Memo	0.00							
Quality Control									

130	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
									
Powdercoat	Memo	0.00							
Powder Coating									

*** mask sides of hinge prior to powdercoat***
 Start Time: 9:00
 Oven Temperature: 320 OF
 Finish Time: 9:30

140	Wing Walk as per dwg QSI005 4.4 Batch	0.00							
									
HandFinish	Memo	0.00							
Hand Finishing									

1- Mask data plate and apply wing walk on outside surface of mesh as per dwg
 2- Install placard and label as per dwg
 ***Mask label plate to size of label, use scotchbrite red pad to lightly sand area for label, apply label ***

IX Ø M-11/08/16

IX Ø M-11/08/16

Winkwalk M118313

M115128

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Wednesday, August 03, 2011 2:45:52 PM



Page 3

Item ID: D3914-041

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Revision ID:

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Start Date: 8/3/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/12/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

EP 11/08/17 ①

160

Identify as per dwg & Stock Location: 6-A

0.00



Packaging

Memo

0.00

Packaging

w/o
72648

EP 11/08/17 ②

170

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/8/24 ③

11-08-24 ④

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, August 03, 2011 2:45:48 PM

Page 1

Work Order ID: 72650

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)



Start Date: 8/3/2011




Required Date: 8/12/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A new issue DD 10.03.19 verified by:EC
as per dwg revB DD 10.08.18 verified by:EC

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2581  Mounting Bracket		Manufactured	No			100	Each	63.0000	2	2		<i>PMB 11/08/04</i>	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		63							
					69258	28							
					69739	2							
					70760	33			<u>2</u>				
D3914-1  Rib		Manufactured	No			100	Each	7.0000	2	2		<i>PMB 11/08/03</i>	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		7							
					71392	3			<u>1</u>				
					72087	4			<u>1</u>				
D3914-7  Rib		Manufactured	No			100	Each	8.0000	2	2		<i>PMB 11/08/03</i>	
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				WA		8							
					71481	4			<u>2</u>				
					71942	4							

PMB 11/08/04

PMB 11/08/03

PMB 11/08/03

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

Wednesday, August 03, 2011 2:45:48 PM

Page 2

Work Order ID: 72650

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 8/3/2011

Required Date: 8/12/2011

Start Qty: 1.00

Required Qty: 1.00

D4016-3 Manufactured No

100 Each

34.0000

3 3



Hinge Half, Lid



PMB 11/08/04

Location

Loc Qty

Loc Code

WA

18

72116

18

WA005

16

71941

16

D4018-5 Manufactured No

100 Each

42.0000

9 9



Rib



PMB 11/08/03

Location

Loc Qty

Loc Code

WA

42

70758

5

71939

18

72339

19

D4020-5 Manufactured No

100 Each

6.0000

1 1



Mesh (350 Basket Long, Lid)



PMB 11/08/05

Location

Loc Qty

Loc Code

WA

6

68234

1

69162

1

71828

4

D4021-3 Manufactured No

100 Each

12.0000

1 1



Data Plate



PMB 11/08/11

Location

Loc Qty

Loc Code

WA

12

71943

12

Wednesday, August 03, 2011 2:45:49 PM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, August 03, 2011 2:45:49 PM

Page 3

Work Order ID: 72650

Parent Item: D3914-041

Parent Item Name: Long Basket Lid Assembly (350)

Start Date: 8/3/2011

Required Date: 8/12/2011

Start Qty: 1.00

Required Qty: 1.00

D4035-041

Manufactured No

100

Each

3.0000

1

1



Lid Rib Assembly, Fwd (350 Basket)



PAB 11/08/11

Location

Loc Qty

Loc Code

WA

3

63720

0

71484

1

72088

2

B72541 → ①

D4035-043

Manufactured No

100

Each

6.0000

1

1



Lid Rib Assembly, Aft (350 Basket)



PMB 11/08/03

Location

Loc Qty

Loc Code

WA

3

71979

3

WA006

3

72439

3

D2728-3

Manufactured No

140

Each

0.0000

1

1



Dart Logo label



MUSOSO

IX M. 11/08/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

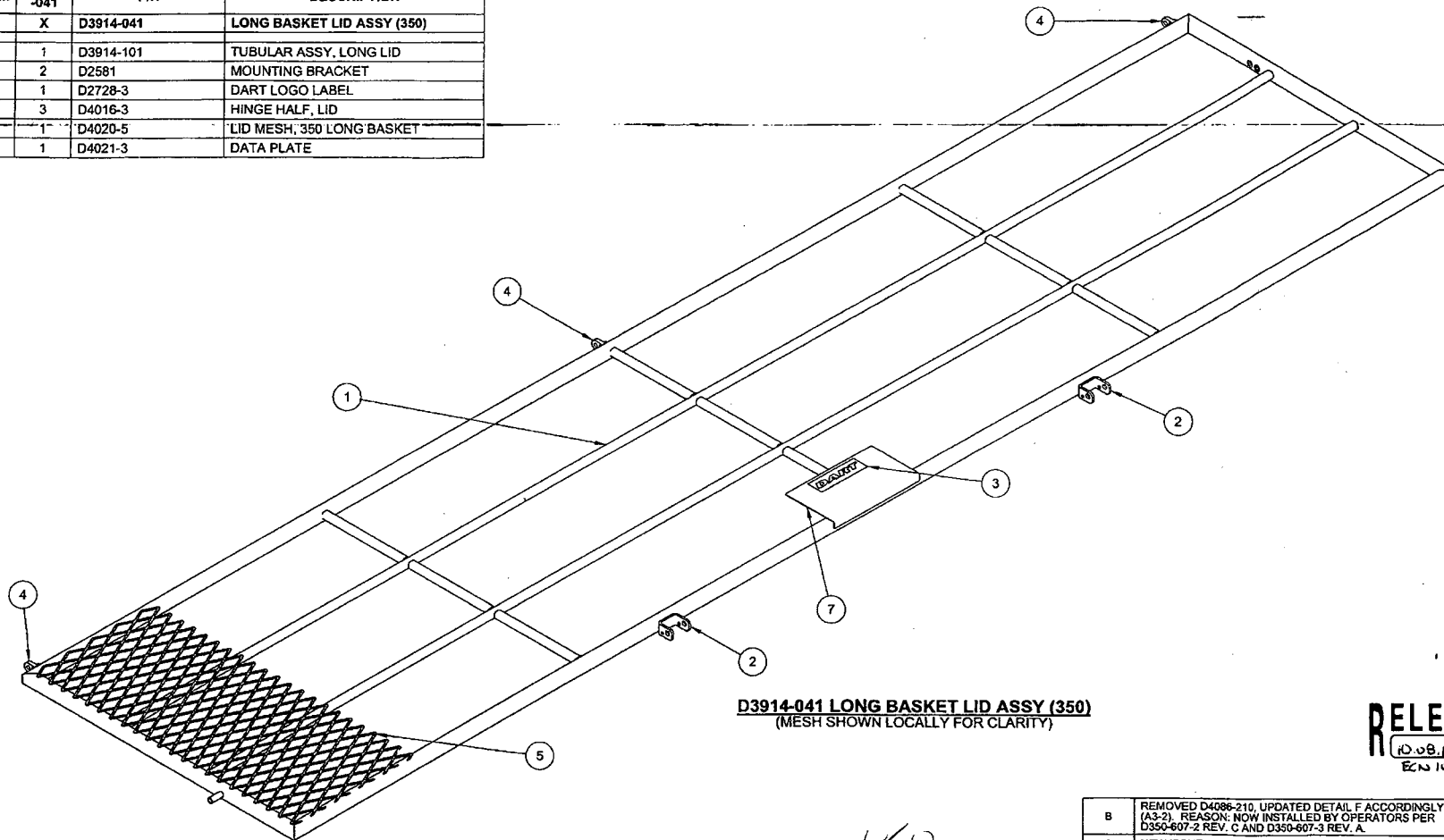
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

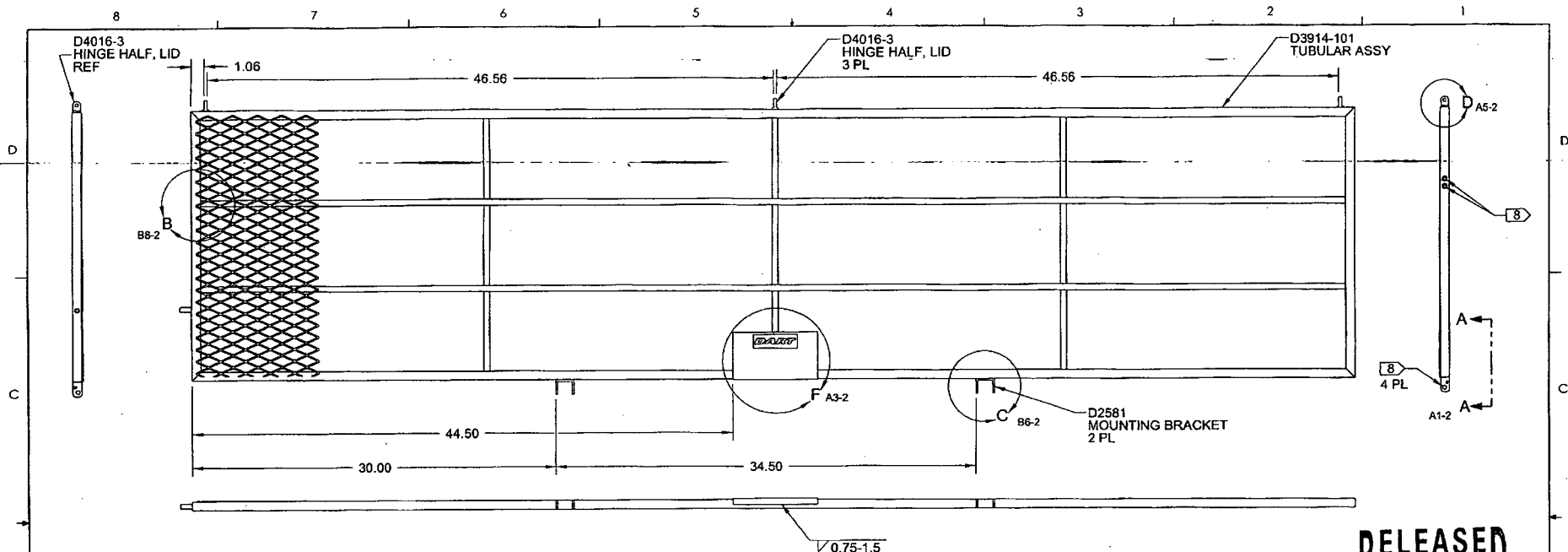
ITEM	QTY -041	P/N	DESCRIPTION
	X	D3914-041	LONG BASKET LID ASSY (350)
1	1	D3914-101	TUBULAR ASSY, LONG LID
2	2	D2581	MOUNTING BRACKET
3	1	D2728-3	DART LOGO LABEL
4	3	D4016-3	HINGE HALF, LID
6	1	D4020-5	LID MESH, 350 LONG BASKET
7	1	D4021-3	DATA PLATE



D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

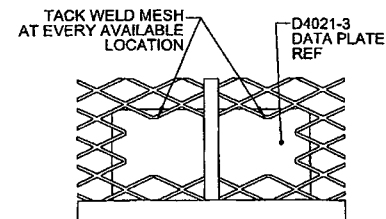
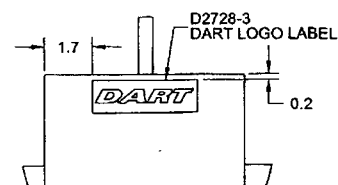
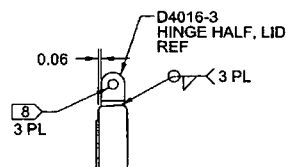
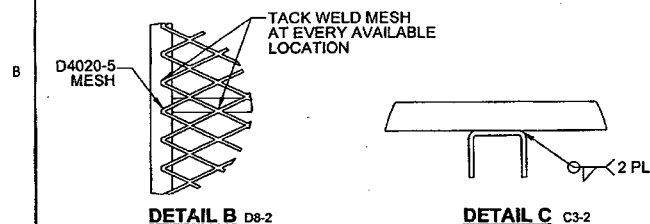
RELEASED
10.08.17
ECN 10-596

B	REMOVED D4086-210, UPDATED DETAIL F ACCORDINGLY (A3-2). REASON: NOW INSTALLED BY OPERATORS PER D350-607-2 REV. C AND D350-607-3 REV. A.	MB	10.08.05
A	NEW ISSUE	JPH	10.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	ALS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC	DRAWING NO.	REV. B
CHECKED	SC	D3914	SHEET 1 OF 4
MFG. APPR.	SC	TITLE	SCALE
APPROVED	SC	LONG BASKET LID ASSY (350)	NTS
DE APPR.	SC	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR LOANED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	10.08.05		



RELEASED
10.08.12 CP

D3914-041 LONG BASKET LID ASSY (350)
(MESH SHOWN LOCALLY FOR CLARITY)



NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT TO OUTSIDE SURFACE OF MESH PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 22.35 lbs APPROX
- 8) MASK HOLES PRIOR TO FINISHING
- 9) WELD PER DART QSI 004

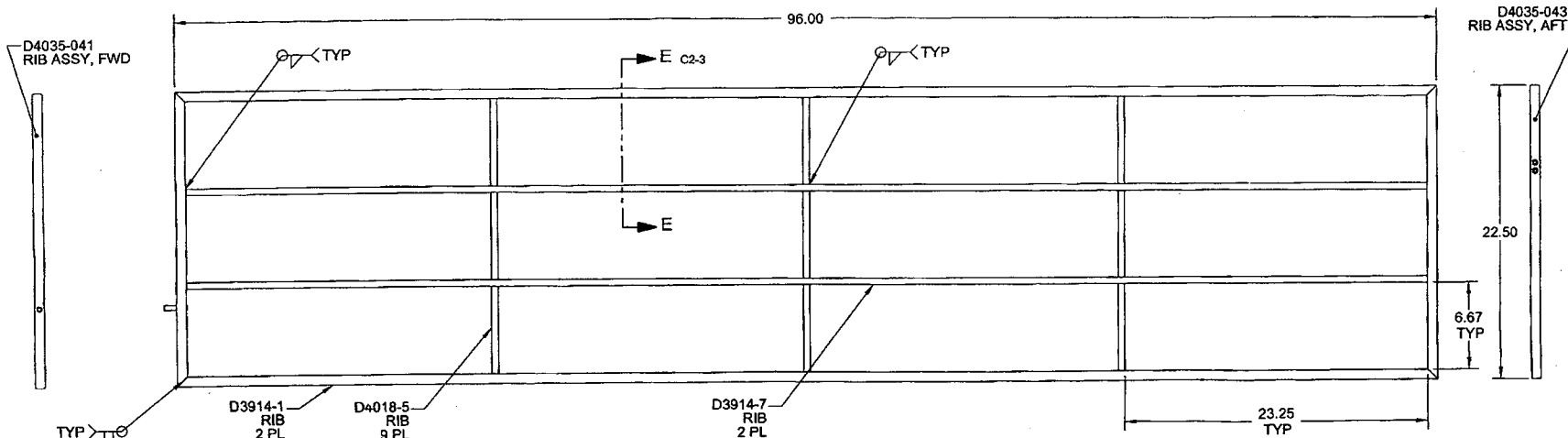
72650

DESIGN	ALS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	SC	DRAWING NO.	REV. B
CHECKED	SC	D3914	SHEET 2 OF 4
MFG. APPR.	SC	TITLE	SCALE
APPROVED	SC	LONG BASKET LID ASSY (350)	NTS
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ITEM	QTY -101	P/N	DESCRIPTION
	X	D3914-101	TUBULAR ASSY, LONG LID (350)
1	2	D3914-1	RIB
2	2	D3914-7	RIB
3	9	D4018-5	RIB
4	1	D4035-041	BASKET LID RIB ASSY, FWD
5	1	D4035-043	BASKET LID RIB ASSY, AFT



SECTION E-E C5-3



8 D3914-101 TUBULAR ASSY, LONG LID

RELEASED
10-28-12

NOTES:

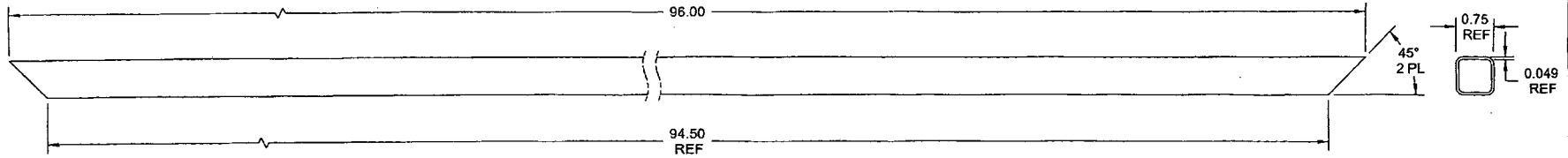
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 14.10 lbs
- 8) TOLERANCE FOR XX.XX DIMENSIONS ± 0.06 FOR D4018-101
- 9) WELD PER DART QSI 004

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	BC	DRAWING NO.	REV. B
MFG. APPR.	WJ	D3914	SHEET 3 OF 4
APPROVED	WJ	TITLE	SCALE
DE APPR.	WJ	LONG BASKET LID ASSY (350) NTS	
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

D

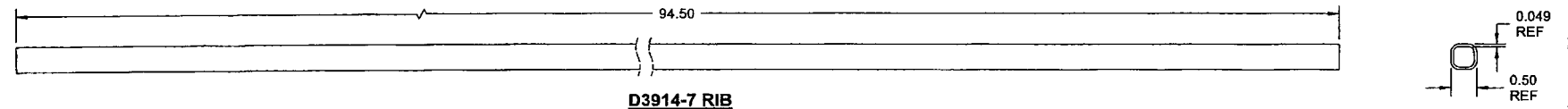
D



D3914-1 RIB

C

C



D3914-7 RIB

B

B

NOTES:

- 1) MATERIAL -1: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL
REF DART SPEC. M304TS0.750W.049
- 2: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL
REF DART SPEC. M304TS0.500W.049

- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: SEE ASSEMBLED WEIGHTS

72650

RELEASED
10.08.12.4

DESIGN	ALS	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	SC	DRAWING NO.	- REV. B
MFG. APPR.		D3914	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		LONG BASKET LID ASSY (350)	NTS
DATE	10.08.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
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8 7 6 5 4 3 2 1

A

A